

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027451**Date Inspected:** 13-Apr-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1350**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** job site**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Quality Assurance (QA) Inspector Danny Smith arrived at the new San Francisco Oakland Bay Bridge to observe, document and perform a general visual verification and NDT. Upon arrival as noted above the QA Inspector observed Quality Control (QC) on site performing welding inspection.

Longitudinal Stiffener plate:

The QA Inspector at random intervals, observed ABF welder Mike Jiminez (ID 4671) perform the Shielded Metal Arc Welding (SMAW) process in the 3G vertical position on face "B" of the longitudinal stiffener plate 5W-PP36. 5-W2-LSE on the interior of the OBG. The welder was observed utilizing 3.2mm E9018-H4R electrodes obtained from a baking oven and drawing amperage of 126. QC Inspector was on hand to monitor the welding, parameters and measure the inter-pass temperatures as they apply to ABF-WPS-D1.5-1012-3. On subsequent observations the welder was observed cleaning the work between passes by employing a small disc grinder, brushes and compressed air. The QA Inspector noted the welding at this location completed at this time on this date.

Later in the shift the QA Inspector observed the welder back gouging side "B" for welding. The QA Inspector observed the QC Inspector perform Magnetic Particle Test (MT) on the back gouge. The QC Inspector relayed to the QA Inspector no relevant indications were found at this time on this date. The QA Inspector noted the welding at this location not completed on this date.

The QA Inspector at random intervals, observed ABF welder Steve Davis (ID 7889) perform the Shielded Metal Arc Welding (SMAW) process in the 3G vertical position on face "B" of the longitudinal stiffener plate 5W-PP36. 5-W2-LSW on the interior of the OBG. The welder was observed utilizing 3.2mm E9018-H4R electrodes obtained

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from a baking oven and drawing amperage of 132. QC Inspector was on hand to monitor the welding, parameters and measure the inter-pass temperatures as they apply to ABF-WPS-D1.5-1012-3. On subsequent observations the welder was observed cleaning the work between passes by employing a small disc grinder, brushes and compressed air. The QA Inspector noted the welding at this location completed at this time on this date.

Later in the shift the QA Inspector observed the welder back gouging side "B" for welding. The QA Inspector observed the QC Inspector perform Magnetic Particle Test (MT) on the back gouge. The QC Inspector relayed to the QA Inspector no relevant indications were found at this time on this date. The QA Inspector noted the welding at this location not completed on this date.

The QA Inspector observed the QC Inspector perform Ultra-Sonic Test (UT) at location 8E-PP61.5-ES-LSE. The QC Inspector relayed to the QA Inspector two relevant indications was found. The QC Inspector relayed to the QA Inspector the indications would be repaired per approved repair procedures at a later date.

Work performed appears to be in general compliance with contract documents.



Summary of Conversations:

Conversations included welding work being performed on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Smith,Danny

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer
